

Date: Wednesday, 11/03/2009 1:00:12 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	DOUBLER
Job Number :	46457D		
Estimate Number :	10296		
P.O. Number :		Part Number :	D32203
This Issue :	11/03/2009	Drawing Number :	D3220
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	11	Drawing Revision :	A1
Previous Run :	46337	Material :	
Written By :		Due Date :	27/03/2009
Checked & Approved By :	Qty: 8 Um: Each		
Comment :	: Est Rev: A New Issue 05-11-06 JLM Est: B 06.11.15 waterjet EC Est C: 08.11.26 Comment added to step 2 KJ Verified by: eC		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M2024T3S050

2024-T3 .050 sheet



Comment: Qty.: 0.6233 sf(s)/Unit Total : 4.9862 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.050" thick
 (M2024T3S.050)
 Identify for D3220-3
 Batch: 10774 B 9-4-5

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3220
 Dwg Rev: A1 B 9-4-5
 Prog Rev: A1

8

2-Deburr if necessary

B 9-4-5

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 9-4-5

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

50/04/06 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/03/2009 1:00:12 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 46457D

Part Number: D32203

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(X8)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

UMD/BR

09/04/07

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(8)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL

09/04/07

7.0

PACKAGING 1

PACKAGING RESOURCE #1



SD

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 181

9/4/7

(8K)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-04-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

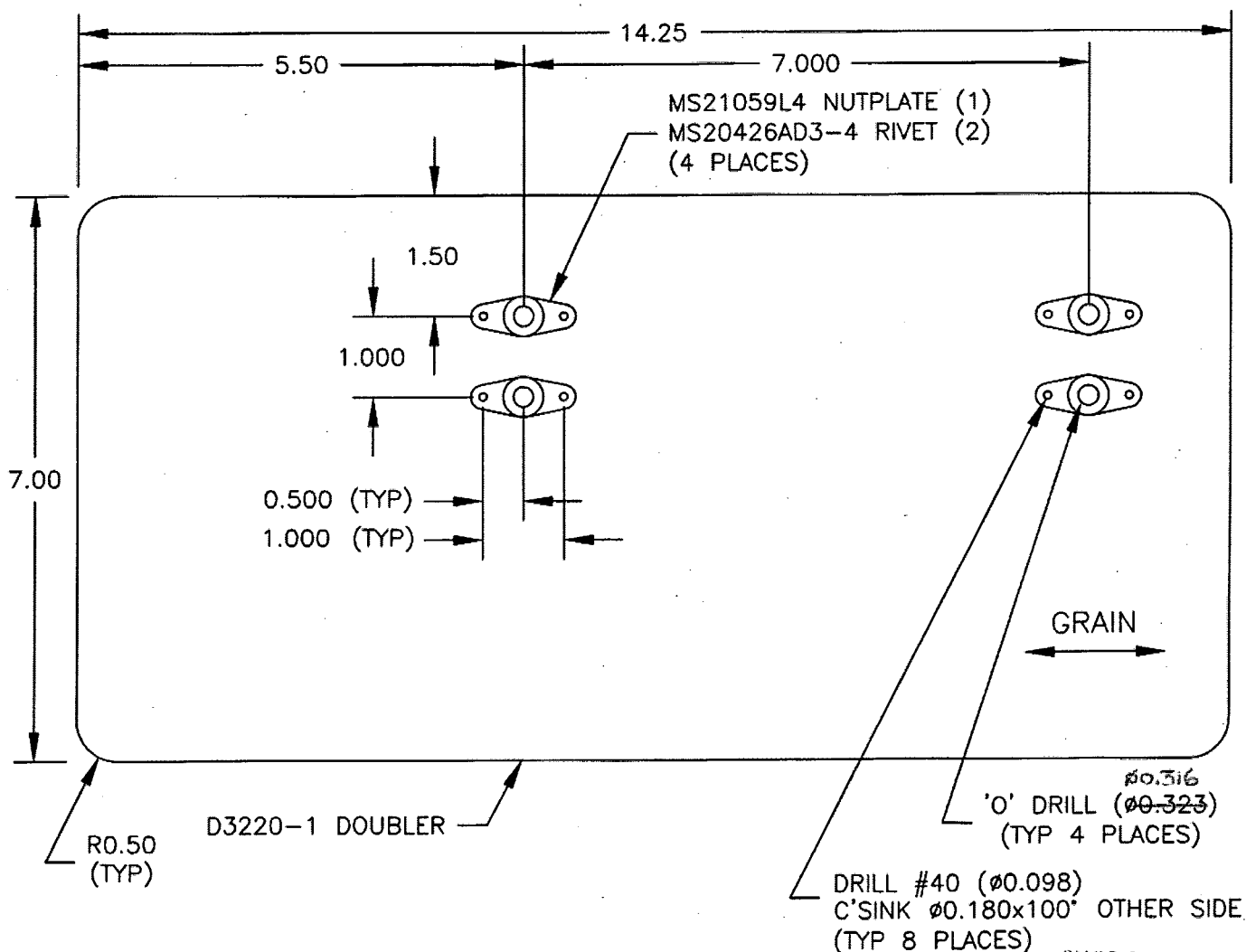
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	<i>[Signature]</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3220 REV. A SHEET 1 OF 2
DATE	03.10.16	TITLE	DOUBLER	SCALE 1:2
A	03.10.16	NEW ISSUE		
A1	<i>CP</i> <i>[Signature]</i> 03.11.13	CORRECTED DIM.		

RELEASED
03.11.14 *[Signature]*



D3220-041 (SHOWN) / -042 (OPPOSITE) DOUBLER ASSEMBLY (D3220-1 DOUBLER)

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
(REF DART SPEC. M2024T3S.090)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. *[Signature]*

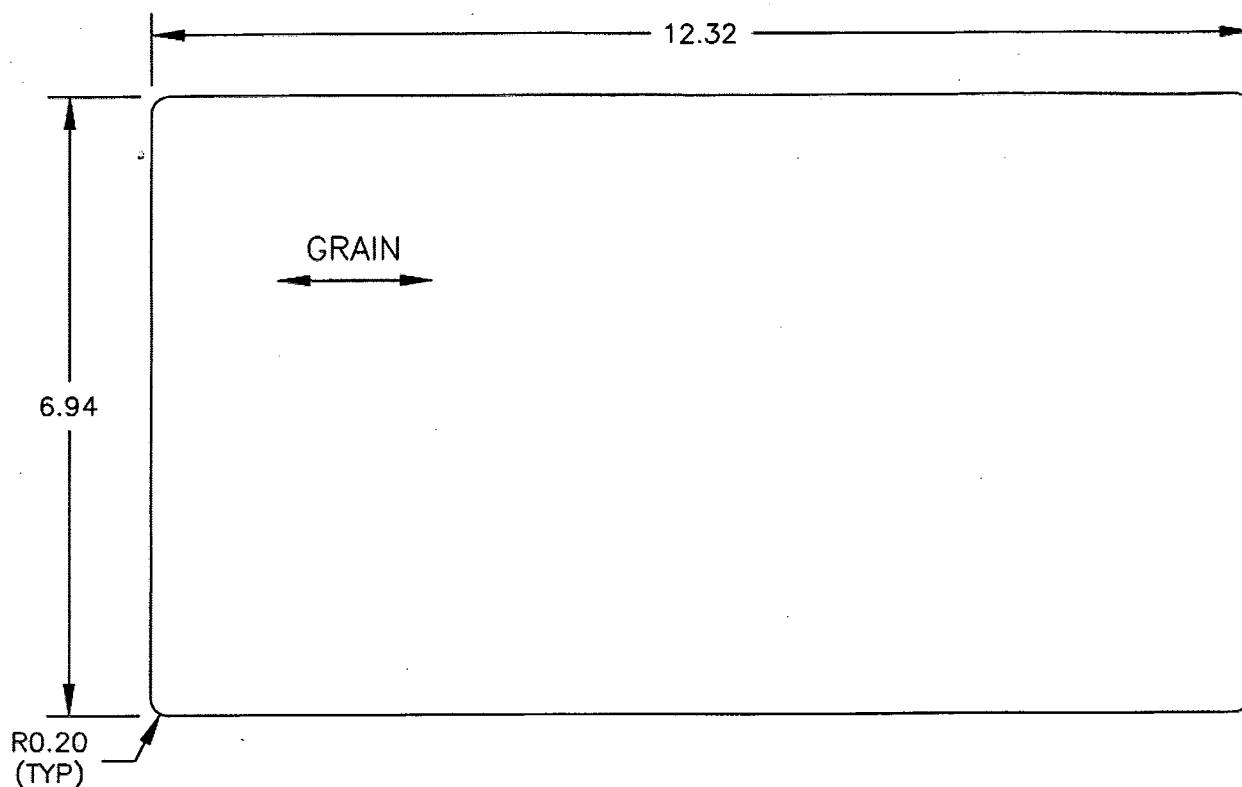
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DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3220	REV. A SHEET 2 OF 2
DATE 03.10.16		TITLE DOUBLER	SCALE 1:2

RELEASED
03.11.14 #



D3220-3 DOUBLER

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
(REF DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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